



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-012

Job Sheet 172347



Part No: D350-636-012

Job Qty: 1 pcs

Part Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/15/18

Job Tracking No:

Due Date: 2/28/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D3492 REV E SHEET 1, D2750-042 REV G SHEETS 1,2,5,9 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
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Container No: S047355



Part: D350-636-012

Job No: 172347

Serial No/Batch: S047355

Revision:

Inspector:

Date: 03/02/18

S047355 R+1

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/27/18	0.00	0.00	Start Up Skid tubes-1		
110	Skid tubes	1 pcs		2/27/18	0.00	4.36	Skid tubes-4		BL-DAS
120	QC	1 pcs		2/27/18	0.00	0.00	QC10		38 DAS
130	QC	1 pcs		2/27/18	0.00	0.00	QC5		9-88 38
140	HandFinish	1 pcs		2/27/18	0.00	0.91	HandFinish1		SA 18-3-887
150	QC	1 pcs		2/27/18	0.00	0.00	QC7-2		38 DAS
160	Skid tubes	1 pcs		2/27/18	0.00	4.36	Skid tubes-1		38 DAS
170	QC	1 pcs		2/27/18	0.00	0.00	QC10		9-88 38
180	QC	1 pcs		2/27/18	0.00	0.00	QC5		SA 18-3-887
190	HandFinish	1 pcs		2/27/18	0.00	0.91	HandFinish2		SA 18-3-887
200	Spray Paint	1 pcs		2/27/18	0.00	0.69	Spray Paint		SA 18-3-887
210	QC	1 pcs		2/27/18	0.00	0.00	QC14		SA 18-3-887
230	HandFinish	1 pcs		2/28/18	0.00	0.91	HandFinish4		SA 18-3-887
240	QC	1 pcs		2/28/18	0.00	0.00	QC5		SA 18-3-887
250	Packaging	1 pcs		2/28/18	0.00	0.00	Packaging1-3		SA 18-3-887
260	QC	1 pcs		2/28/18	0.00	0.00	QC4		SA 18-3-887
265	DC	1 pcs		2/28/18	0.00	0.00	DC		SA 18-3-887
270	Packaging	1 pcs		2/28/18	0.00	0.00	Packaging3-1		SA 18-3-887
280	QC21-FG	1 Ea		2/28/18	0.00	0.00	QC21		SA 18-3-887
330	Packaging	1 pcs		2/28/18	0.00	0.00	Packaging2		SA 18-3-887

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill jig DT8450 & DT8863A for second side only DT8863B for first side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750

160 - 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 4134-727 exp. date: 89-814 **ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: Q38617 9- At section AP-AP drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2-

PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____

210 - Inspect for foreign object per QSI 024

230 - 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: _____ EXP DATE: _____ 4-

assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: _____ 5-Coat all exposed fasteners with "LPS Procyon" batch: _____

265 - record fwd angle: 89.70 Photocopy blue file and type labels per PPP D350-636-012 CHG 007

270 - Package as per PPP D350-636-012

Job BOM					001764
Part / Item	Component Name	Quantity	Operation	Container	
D2600-3-BENT-RH	Extrusion Bent RH	1 Ea (1 ea)	90-Start up Operation	5043941	
D2744	Cap	1 Ea (1 ea)	90-Start up Operation	5038835	
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5040307	
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5026588	
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5017322	
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5040318	
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5048375	
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	5019396	
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5019397	
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	FW137055	
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	FM137073	
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5026936	
D3488-042	Blade Fitting RH	1 Ea (1 ea)	230-HandFinish	5040148	
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	5025617	
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	5026057	
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	5047122	
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	5046421	
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	5037108	
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5048060	
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5021791	
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	5038363	
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5032647	
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	5031919	
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	5046241	
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5041601	
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5034401	
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5044236	
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	M138409-121	
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	FM137361-25	
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5049970	
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	5022099	
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging		
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging		
D3493-1	Washer	2 Ea (2 ea)	250-Packaging		
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging		
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5016880	
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5025268	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	0	0
	D2744	1	28	0
160-Skidtubes	D2739	1	27	0
	D2743	8	151	0
	D3490-1	4	128	0
	D3490-3	4	107	0
230-HandFinish	ALS4-1032-225	38	1,079	0
	AN3C5A	34	807	0
	AN3C6A	4	170	0
	AN6C44A	4	447	0
	AN8C35A	1	73	0
	D2745	8	105	0
	D3488-042	1	14	0
	D3492-1	8	99	0
	D3492-3	8	152	0
	D3535-25	1	25	0
	D3536-25	1	16	0
	D3537-1	3	105	0
	D3631-1	8	54	0
	D3791-1	1	11	0
	D3793-1	1	28	0
	D3793-3	1	30	0
	D3794-1	1	20	0
	D3794-3	1	10	0
	MS21043-6	4	123	0
	MS21083C8	1	95	0
	NAS1149C0332R	38	2,037	0
	NAS1149C0832R	1	98	0
	NAS1515H3L	4	295	0
	NAS1611-010	8	279	0
	NAS1611-013	8	367	0
250-Packaging	AN8C21A	2	187	0
	D2741	1	84	0
	D3493-1	2	44	0
	D3532-1	2	58	0
	MS21083C8	2	95	0
	NAS1149D0863J	2	171	0
Part Specifications				
Specifications could not be found.				

Plex 2/15/18 1:54 PM Dart.Gagnon.Michelle

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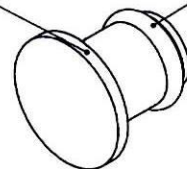
WORK ORDER

NO. 172347 *mtf.*

FEB 15 2018

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X								D3492-041	PLUG ASSEMBLY
	X							D3492-043	PLUG ASSEMBLY
		X						D3492-045	PLUG ASSEMBLY
			X					D3492-047	PLUG ASSEMBLY
				X				D3492-049	PLUG ASSEMBLY
					X			D3492-051	PLUG ASSEMBLY
						X		D3492-053	PLUG ASSEMBLY
							X	D3492-055	PLUG ASSEMBLY
1								D3492-1	PLUG
	1							D3492-3	PLUG
		1						D3492-5	PLUG
			1					D3492-7	PLUG
				1				D3492-9	PLUG
					1			D3492-11	PLUG
						1		D3492-13	PLUG
							1	D3492-15	PLUG
		1						NAS1611-005	O-RING
			1					NAS1611-007	O-RING
1								NAS1611-010	O-RING
						1		NAS1611-012	O-RING
	1							NAS1611-013	O-RING
					1		1	NAS1611-015	O-RING
				1				NAS1611-016	O-RING

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED
2013-11-13

E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047: UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	<i>AJS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3492	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLUG	NTS
DATE	13.08.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

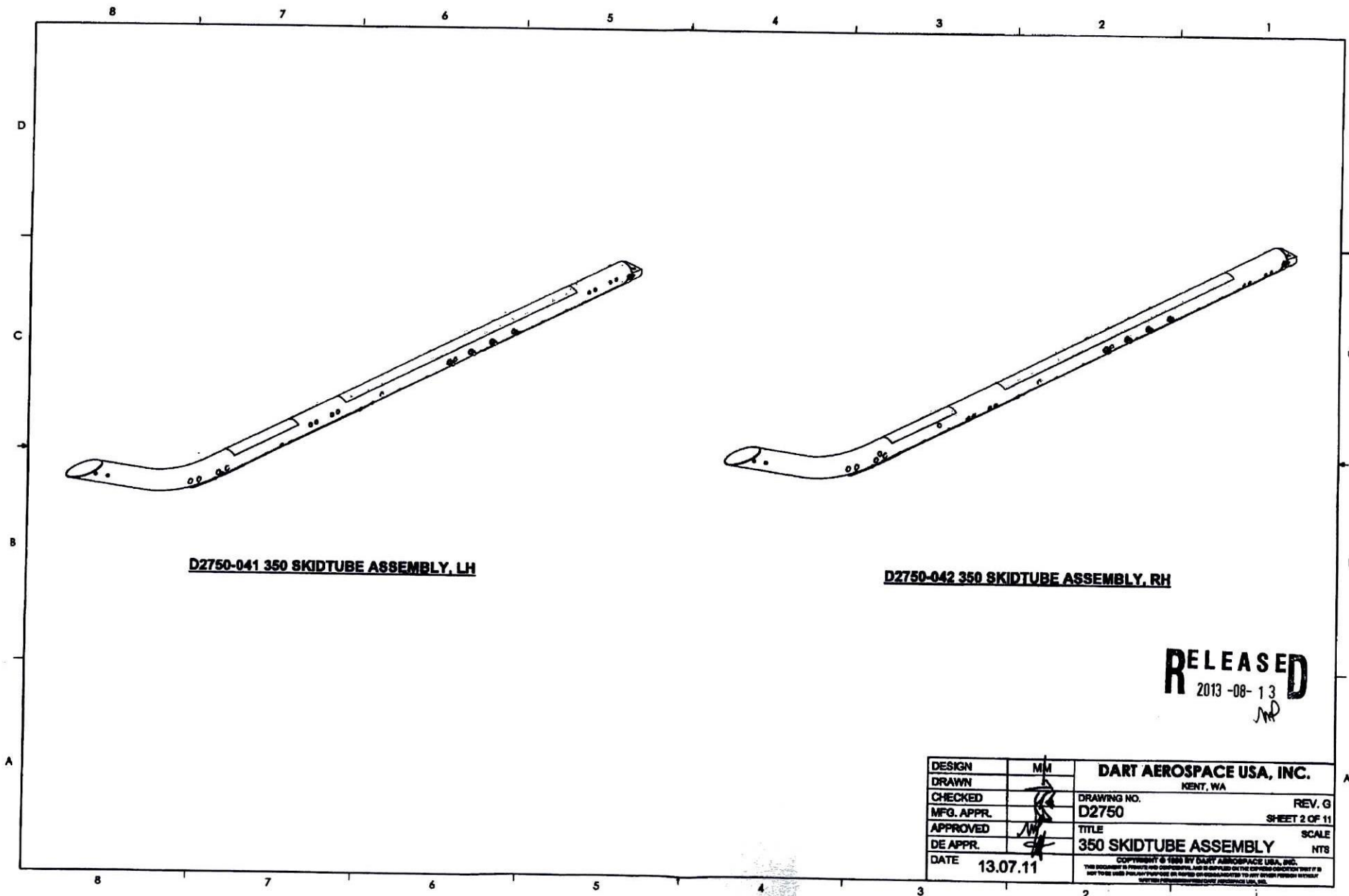
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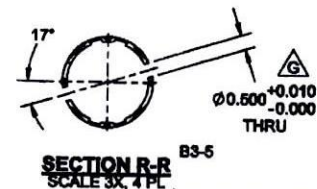
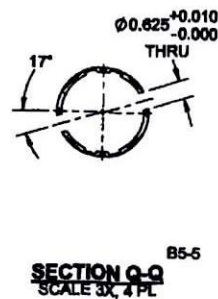
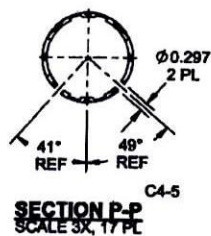
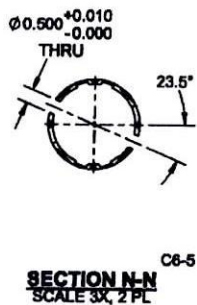
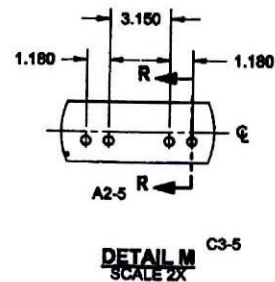
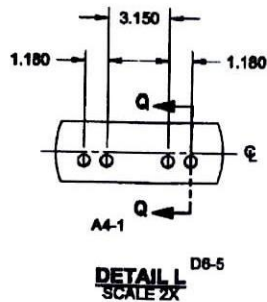
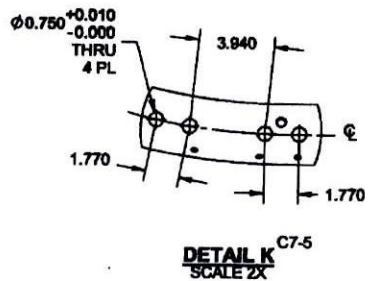
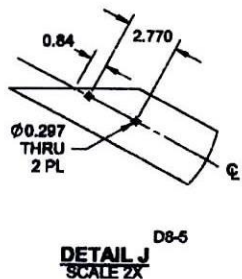
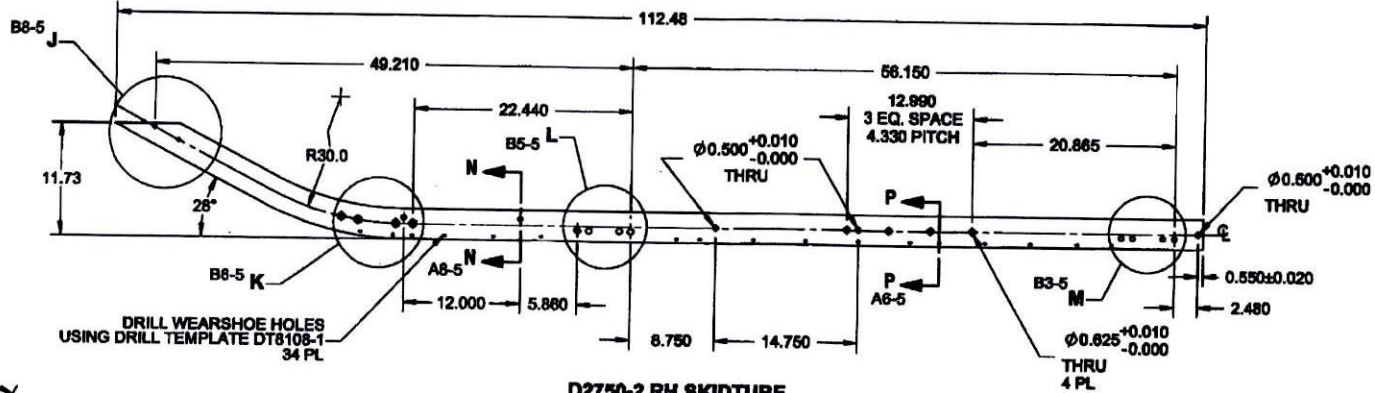
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED
2013-08-13
ND

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-278 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DSO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24894-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

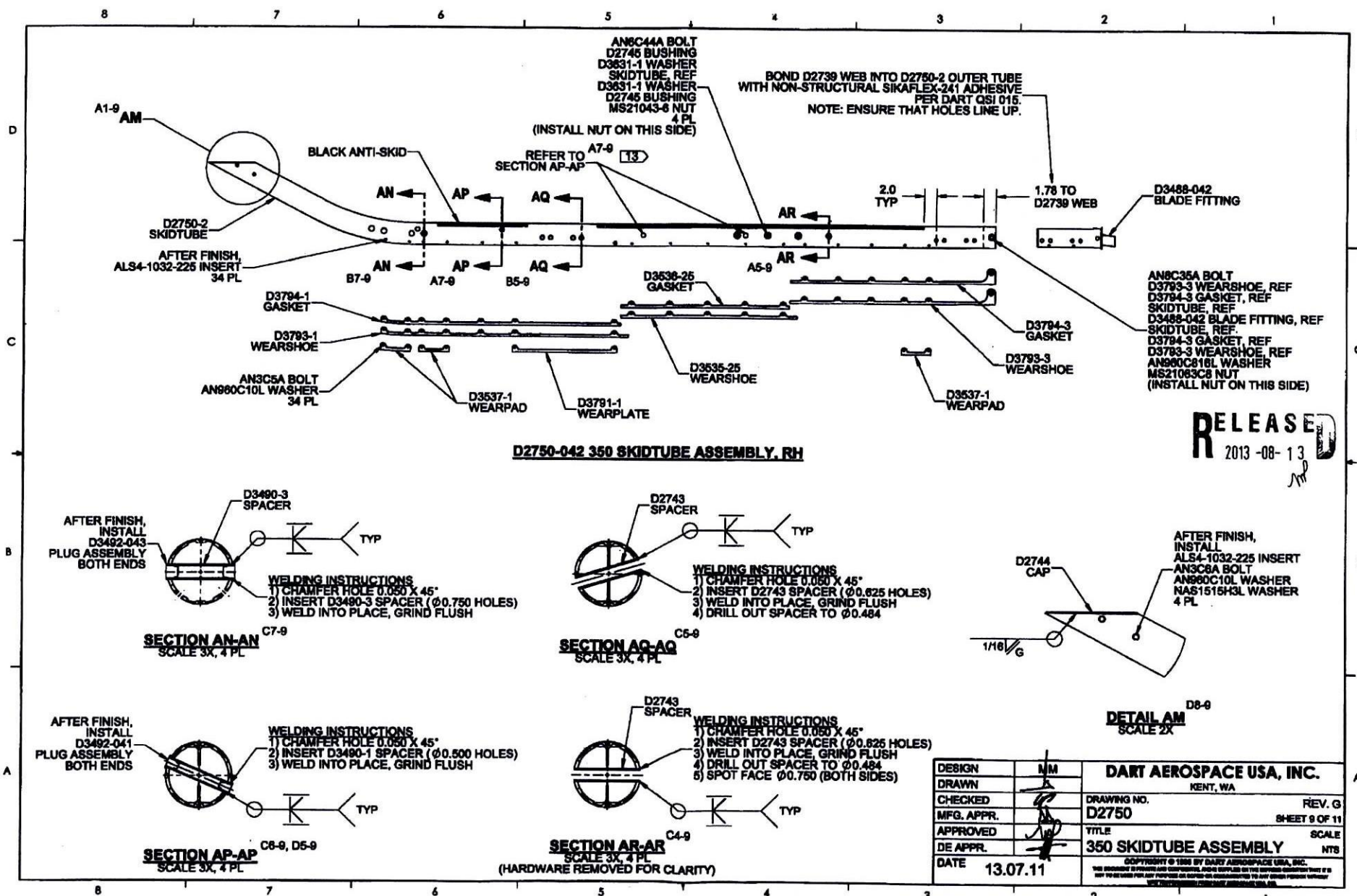
DART AEROSPACE USA, INC.
KENT, WA
DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
REV. G
SHEET 1 OF 11
SCALE
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RELEASED
2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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Dart Aerospace Ltd.
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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001764	S053452	AN8C21A	Bolt	fm137162	OVER004	2
001764	S053451	D2741	Replacement Blade	F163260-1	ST538	1
001764	S053450	D3493-1	Washer	S031096	ST037	2
001764	S053448	D3532-1	Spacer	S040493	ST038	2
001764	S053419	MS21083C8	Nut	S016888	ST297	1
001764	S053418	NAS1149D0863J	Washer	F125268	ST263	2

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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